

# Work Order ID 82392

**\*82392\***

Page 1

March-30-12 7:47:49 AM

Item ID: K642-512

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: saddle kit 642-512

Stop

**\*NS2\***

Start Date: 29/03/2012 Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 12/04/2012 Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/03/10

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
IIN-D206-642	O								
100	DOCUMENT CONTROL	0.00							
<b>*100*</b>									
DC	Memo	0.00							
Document Control	Create White labels per PPP K642-512 CHG004								
110	Pick Kit	0.00							
<b>*110*</b>									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
<b>*120*</b>									
QC	Memo	0.00							
Quality Control									

*ff for mls 12-5-28*  
*(3)*

*(3v)* *12/5/28*

*(+3)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

**\*82392\***

Page 2

**Accept**

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 29/03/2012    **Start Qty:** 2.00    **\*2\***

**Cust Item ID:**

**Required Date:** 12/04/2012      **Req'd Qty:** 2.00      **\*~\***

**Customer:**

**Reference:**

**Approvals:**      **Process Plan:** \_\_\_\_\_      **Date:** \_\_\_\_\_      **Tooling:** \_\_\_\_\_      **Date:** \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

0.00

**\*130\***

## Packaging

0.00

### Packaging

## Memo

## Packaging

Identify and pack for shipping as per PPP K642-512 Location: PK

Reva

140

QC21- Final Inspection - Work Order Release

0.00

**\*140\***

QC

## Memo

0.00

## Quality Control

32 6/6/55f

12/6/6 JH  
mk  
12-06-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

March-30-12 7:47:52 AM

Page 1

Work Order ID: 82392

\*82392\*

Parent Item: K642-512

\*K642-512\*

Parent Item Name: saddle kit 642-512

Start Date: 29/03/2012

Required Date: 12/04/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev.A 05.06.07 new issue EC  
IPP Rev.B 05.02.08, Per ECN1080P

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN5C34A		Purchased	No			110	Each	68.0000	2				
---------	--	-----------	----	--	--	-----	------	---------	---	--	--	--	--

\*AN5C34A\*

\*\*

## Location

## Loc Qty

## Loc Code

FG	2	
18918	2	
ST339	66	
119083	11	
119530	30	
121013	25	

D206-648-013

CH6002

Manufactured No

110 Each 15.0000

\*D206-648-013\*

GHW Modification

\*\*

## Location

## Loc Qty

## Loc Code

FG	3	
78875	3	
FG120	12	
65455	0	
66633	0	
81332	12	

23  
B83362 12/5/30

W/O:		WORK ORDER CHANGES					
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Page 2

Work Order ID: 82392

Parent Item: K642-512

Parent Item Name: saddle kit 642-512

\*82392\*

\*K642-512\*

Start Date: 29/03/2012

Required Date: 12/04/2012

Start Qty: 2.00

Required Qty: 2.00

D2932-2

Manufactured No

110

Each

14.0000

\*D2932-2\*

Saddle RH Out, 206

\*\*

## Location

## Loc Qty

## Loc Code

ST421

4

79224

4

ST428

10

75100

4

78986

6

D2933-2

Manufactured No

110

Each

15.0000

\*D2933-2\*

Saddle RH In, 206

\*\*

## Location

## Loc Qty

## Loc Code

ST421

4

79227

4

ST428

11

74604

3

75101

4

78963

4

D2938-2

Manufactured No

110

Each

16.0000

\*D2938-2\*

Saddle RH Out, 206

\*\*

## Location

## Loc Qty

## Loc Code

ST421

4

79229

4

ST428A

12

75102

4

81622

8

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 82392

Parent Item: K642-512

Parent Item Name: saddle kit 642-512

\*82392\*

\*K642-512\*

Start Date: 29/03/2012

Required Date: 12/04/2012

Start Qty: 2.00

Required Qty: 2.00

D2939-2

Manufactured No

110

Each

16.0000

\*D2939-2\*

Saddle RH Lin 206

\*\*



23

B82134

## Location

## Loc Qty

## Loc Code

ST421

4

79231

4

ST428A

12

74608

3

75103

3

78955

6

Purchased

No

110

Each

144.0000

\*\*



16-24

AN3C41A

\*AN3C41A\*

BOLT

## Location

## Loc Qty

## Loc Code

FG

4

103324

4

ST354

140

119673

50

120753

30

121013

50

121067

10

Manufactured

No

110

Each

532.0000

\*\*



32 48

B83744

12/5/2012

D2652

\*D2652\*

Bushing

## Location

## Loc Qty

## Loc Code

FG

44

31985

44

ST013

488

73836

36

77134

375

77136

77

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Parent Item: K642-512

Parent Item Name: saddle kit 642-512

\*82392\*

\*K642-512\*

Start Date: 29/03/2012

Required Date: 12/04/2012

Start Qty: 2.00

Required Qty: 2.00

MS21043-3

Purchased

No

110

Each

613.0000

\*MS21043-3\*

Nut

\*\*

40 60  
M121255 d

Location

Loc Qty

Loc Code

FG

72

103691

72

GA

270

120693

270

ST301

271

118077

2

118614

219

118686

30

119758

20

D3672-7

Manufactured

No

110

Each

1,144.0000

\*D3672-7\*

Phenolic Washer

\*\*

48 72  
5d

Location

Loc Qty

Loc Code

ST060

1144

73488

16

76279

628

81872

500

72

AN5C11A

Purchased

No

110

Each

192.0000

\*AN5C11A\*

Bolt

\*\*

16 24  
12/5/30 d

Location

Loc Qty

Loc Code

FG

4

103715

4

ST337

188

119328

38

120423

50

121009

100

24

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Page 4

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item: K642-512

Parent Item Name: saddle kit 642-512

\*82392\*

\*K642-512\*

Start Date: 29/03/2012

Required Date: 12/04/2012

Start Qty: 2.00

Required Qty: 2.00

AN5C12A

Purchased

No

110

Each

76.0000

\*AN5C12A\*

BOLT

\*\*

Location

Loc Qty

Loc Code

FG

2

18918

2

ST338

74

119328

24

120518

50

AN5C13A

Purchased

No

110

Each

225.0000

\*AN5C13A\*

BOLT

\*\*

Location

Loc Qty

Loc Code

ST338

225

118983

25

119537

100

120562

100

AN960C516L

NAS1149C0532

Purchased

No

110

Each

0.0000

\*AN960C516I \*

WASHER

AN4C6A

Purchased

No

110

Each

294.0000

\*AN4C6A\*

Bolt

\*\*

Location

Loc Qty

Loc Code

FG

4

103344

4

ST356

290

116704

2

120423

200

120521

88

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 82392

\*82392\*

Parent Item: K642-512

\*K642-512\*

Parent Item Name: saddle kit 642-512

Start Date: 29/03/2012

Required Date: 12/04/2012

Start Qty: 2.00

Required Qty: 2.00

D3672-3 Manufactured No

110 Each

602.0000

\*D3672-3\*

Phenolic Washer

\*\* 24 48 72  
B84361

## Location

## Loc Qty

## Loc Code

ST060

602

64176

172

81870

430

AN960C416L NAS 1149C043ZR

Purchased No

110 Each

0.0000

\*AN960C416I \*

WASHER

MS21043-4

Purchased No

110 Each

1,953.000

\*MS21043-4\*

Nut

\*\* 24 48 72 52  
M117291 M121255  
26 39

## Location

## Loc Qty

## Loc Code

FG

40

104603

40

ST301

1913

119546

370

120308

543

121162

1000

D3407-043

Manufactured No

110 Each

33.0000

\*D3407-043\*

Tow Ring

\*\* 39 23  
B77504 12/13/09

## Location

## Loc Qty

## Loc Code

ST420

13

79232

13

ST463

20

68339

2

74519

3

78841

15

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 82392

\*82392\*

Parent Item: K642-512

\*K642-512\*

Parent Item Name: saddle kit 642-512

Start Date: 29/03/2012

Required Date: 12/04/2012

Start Qty: 2.00

Required Qty: 2.00

D3456-1

Manufactured No

110 Each

150.0000

\*D3456-1\*

Washer

\*\*

## Location

## Loc Qty

## Loc Code

FG

7

25701

7

ST044

143

80252

43

81876

100

110

Each

99.0000

\*\*

D3457-1

Manufactured No

\*D3457-1\*

Washer

## Location

## Loc Qty

## Loc Code

FG

10

32409

10

ST044

89

67779

1

78801

28

81977

60

110

Each

902.0000

\*\*

D2712

Manufactured No

\*D2712\*

Set Screw

## Location

## Loc Qty

## Loc Code

FG

50

29962

50

ST017

700

79585

500

81871

200

ST021

152

76065

152

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item: K642-512

Parent Item Name: saddle kit 642-512

\*82392\*

\*K642-512\*

Start Date: 29/03/2012

Required Date: 12/04/2012

Start Qty: 2.00

Required Qty: 2.00

D2934

Manufactured No

110

Each

68.0000

\*D2934\*

Saddle Spacer

\*\*

Location

Loc Qty

Loc Code

FG

6

31929

6

ST021

62

74883

8

78802

54

Manufactured No

110

Each

96.0000

D2935

\*D2935\*

Saddle Spacer

\*\*

Location

Loc Qty

Loc Code

FG

6

31793

6

ST021

90

74882

6

78807

84

Purchased No

110

Each

107.0000

AN3C36A

\*AN3C36A\*

BOLT

\*\*

Location

Loc Qty

Loc Code

FG

4

101261

4

ST353

103

116590

0

119083

2

119324

39

121013

55

121167

7

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item: K642-512

Parent Item Name: saddle kit 642-512

\*82392\*

\*K642-512\*

Start Date: 29/03/2012

Required Date: 12/04/2012

Start Qty: 2.00

Required Qty: 2.00

AN3C35A

Purchased

No

110

Each

91.0000

\*AN3C35A\*  
BOLT

\*\*

M12/31/12

Location

Loc Qty

Loc Code

FG

4

18914

4

ST353

87

119125

12

119449

50

121013

25

AN960C10L

NAS1149C0332

Purchased

No

110

Each

0.0000

\*AN960C10L\*  
washer

\*\*

M12/50/12

D3672-1

Manufactured

No

110

Each

1,038.000

\*D3672-1\*  
Phenolic Washer

\*\*

4872

Location

Loc Qty

Loc Code

FP001

34

66821

34

ST060

1004

72229

4

76277

500

80369

500

D3396-3

Manufactured

No

110

Each

35.0000

\*D3396-3\*  
Spacer

\*\*

12/5/12

Location

Loc Qty

Loc Code

FG

10

26772

10

ST041

25

73349

25

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W/O:		WORK ORDER CHANGES					
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Parent Item: K642-512

\*K642-512\*

Parent Item Name: saddle kit 642-512

Start Date: 29/03/2012

Required Date: 12/04/2012

Start Qty: 2.00

Required Qty: 2.00

AN5C35A

Purchased

No

110

Each

51.0000

\*AN5C35A\*

Bolt

\*\*

## Location

## Loc Qty

## Loc Code

ST340

51

108407

1

118451

25

119749

25

AN5C15A

Purchased

No

110

Each

95.0000

\*AN5C15A\*

Bolt

\*\*

## Location

## Loc Qty

## Loc Code

ST338

95

118191

3

119749

12

120422

30

~~120833~~

25

121162

25

AN5C32A

Purchased

No

110

Each

115.0000

\*AN5C32A\*

\*\*

## Location

## Loc Qty

## Loc Code

FG

4

18918

4

ST339

111

117407

11

119035

50

120578

50

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W/O:		WORK ORDER CHANGES					
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Parent Item: K642-512

\*K642-512\*

Parent Item Name: saddle kit 642-512

Start Date: 29/03/2012

Required Date: 12/04/2012

Start Qty: 2.00

Required Qty: 2.00

MS21043-5

Purchased

No

110

Each

475.0000

\*MS21043-5\*

Nut

\*\*

8/2  
12/5/29 sf

Location

Loc Qty

Loc Code

FG

20

101418

20

ST300

30

112314

30

ST301

425

116548

100

118159

100

119307

25

119537

200

12 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng/ Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## 4.7 206L/L-1/L-3/L-4/407 HIGH GEAR FLOAT SKIDTUBES (TRI-BAG COMPATIBLE)

ITEM	QTY -511	QTY -512	QTY -515	QTY -516	QTY -541	QTY -547	QTY -549	QTY -551	QTY -013	PART NUMBER	DESCRIPTION
	X									D206-642-511	SKIDTUBE INSTALLATION, LH
		X								D206-642-512	SKIDTUBE INSTALLATION, RH
			X							D206-642-515	SKIDTUBE INSTALLATION, LH
				X						D206-642-516	SKIDTUBE INSTALLATION, RH
1	1	1			X					D206-642-541	SKIDTUBE
						X				D206-642-547	WEARSHOE KIT (REPLACES -543 KIT)
							X			D206-642-549	RUN-ON LANDING WEARPLATE KIT
			1	1				X		D206-642-551	SKIDTUBE
1	1	1	1	1					X	D206-648-013	-GROUND HANDLING KIT
1					1					D3274-041	SKIDTUBE ASSEMBLY
1								1		D4362-041	SKIDTUBE ASSEMBLY
3					1			1		D2646	* AFT CAP <sup>(1)</sup>
4					2			2		AN3C4A	* BOLT <sup>(1)</sup>
5A					2			2		NAS1149C0332R	* WASHER <sup>(1)</sup> (OR AN960C10L)
5B					2			2		D3672-1	* WASHER (REPLACES NAS1515H3L) <sup>(1)</sup>
6	1		1							D2932-1	SADDLE, FWD OUT, LH
6		1		1						D2932-2	SADDLE, FWD OUT, RH
7	1		1							D2933-1	SADDLE, FWD IN, LH
7		1		1						D2933-2	SADDLE, FWD IN, RH
8	1		1							D2938-1	SADDLE, AFT OUT, LH
8		1		1						D2938-2	SADDLE, AFT OUT, RH
9	1		1							D2939-1	SADDLE, AFT IN, LH
9		1		1						D2939-2	SADDLE, AFT IN, RH
10	8	8	8	8						AN3C41A	BOLT
11	16	16	16	16						D2652	BUSHING
12A	8	8	8	8						MS21043-3	NUT
12B	16	16	16	16						D3672-7	WASHER (REPLACES NAS1515H5)
13	4	4	4	4						AN5C11A (or AN5C12A)	* BOLT <sup>(2)</sup>
14	4	4	4	4						AN5C11A (or AN5C13A)	* BOLT <sup>(2)</sup>
15A	8	8	8	8						NAS1149C0532R	WASHER (OR AN960C516L)
15B	8	8	8	8						D3672-7	WASHER (REPLACES NAS1515H5L)
16	12	12	12	12						AN4C6A	* BOLT
17A	24	24	24	24						D3672-3	WASHER (REPLACES NAS1515H4L)
17B	24	24	24	24						NAS1149C0432R	WASHER (OR AN960C416L)
18	12	12	12	12						MS21043-4	NUT
20A					9	9				D3537-1	* WEARPAD <sup>(1)</sup> (REPLACES D2648-3)
21A					1	1				D3537-3	* WEARPAD <sup>(1)</sup> (REPLACES D3429-1)
22A					1	1				D3535-15	* WEARSHOE <sup>(1)</sup> (REPLACES D2656-15)
22B					1	1				D3536-15	* GASKET <sup>(1)</sup>
23A					1	1				D3535-23	* WEARSHOE <sup>(1)</sup> (REPLACES D2656-23)
23B					1	1				D3536-23	* GASKET <sup>(1)</sup>
24A					1	1				D3535-39	* WEARSHOE <sup>(1)</sup> (REPLACES D3287-1)
24B					1	1				D3536-39	* GASKET <sup>(1)</sup>
25A					1	1				D3535-35	* WEARSHOE <sup>(1)</sup> (REPLACES D2656-35)
25B					1	1				D3536-35	* GASKET <sup>(1)</sup>
26A			8	8	78	78	8			AN3C4A	* BOLT <sup>(1)</sup>
26B			8	8	78	78	8			NAS1149C0332R	* WASHER <sup>(1)</sup> (OR AN960C10L)
26C			8	8	78		8			ALS7-1032-130	* INSERT <sup>(1)</sup> (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
30	1	1	1	1						D3407-043	TOW RING
32A	1	1	1	1						D3456-1	WASHER
32B	2	2	2	2						D3457-1	WASHER
33	1	1	1	1						MS21043-4	NUT
34			1	1	1					AN4C5A	BOLT
35			1	1	1					NAS1149C0463R	WASHER (OR AN960C416)
36			1	1	1					D3413-1	RING
37	10	10	10	10						D2712	SET SCREW
38	2	2	2	2						D2934	SADDLE SPACER
39	2	2	2	2						D2935	SADDLE SPACER

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IIN-D206-642

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ITEM	QTY -511	QTY -512	QTY -515	QTY -516	QTY -541	QTY -547	QTY -549	QTY -551	QTY -013	PART NUMBER	DESCRIPTION
40									2	D3414-041	LUG ASSEMBLY (GHW)
41									4	AN3C37A	BOLT
42									8	D2652	BUSHING
43									4	MS21043-3	NUT
44									4	NAS1149C0363R	WASHER (OR AN960C10)
50	9	9	3	3						AN3C36A	BOLT
51	3	3	3	3						AN3C35A	BOLT
52	24	24	12	12						NAS1149C0332R	WASHER (OR AN960C10L)
53	24	24	12	12						D3672-1	WASHER (REPLACES NAS1515H3L)
54	12	12	6	6						MS21043-3	NUT
55	2	2	2	2						D3396-3	SPACER
56A	1	1	1	1						AN5C35A	BOLT
56B	1	1	1	1						AN5C15A	BOLT
60	2	2	2	2						AN5C32A	BOLT
61	2	2	2	2						AN5C34A	BOLT
62	4	4	4	4						MS21043-5	NUT
80							1	1		D4368-041	FWD WEARPLATE ASSY
81							1	1		D4368-043	AFT WEARPLATE ASSY
82A							1	1		D4383-1	WEARPAD
82B							1	1		D4383-3	WEARPAD
83							20	20		D3873-3	BUSHING
84								24		D3411-3	WASHER
85							2			D3275-1	SPACER
86A							6	6		AN3C40A	BOLT
86B							2	2		AN3C37A	BOLT
86C							2	2		AN3C36A	BOLT
87							10	10		MS21043-3	NUT

NOTES: (1) DENOTES THAT PART IS INCLUDED WITH D3274-041 OR D4362-041 ASSEMBLY ABOVE  
(2) CHOICE OF BOLT WILL DEPEND ON CROSSTUBE (SEE INSTALLATION PROCEDURE)

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